

Work Order ID 71095

Wednesday, June 22, 2011 11:32:41 AM

Page 1

Item ID: D4353-3

Accept

Setup Start

Revision ID: ~~PRELIM~~ *N/A*

Stop

Item Name: Bearpaw Insert

Start Date: 6/22/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 10.00

Customer:

Reference: *LA 11-06-22*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4353

B

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D4355-3 File
Blank: 5.125" x 4.375" x 1.00"*B11-6-28**3**(10)*

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1






1-Inspect material for defects or damage prior to machining
2-Machine as per FolioFB051 and Dwg
FOLIO REV: *AA*
DWG REV: *B**BA 11/06/29**10**φ*

3-Deburr



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Item ID: D4353-3 Accept  Setup Start 
Revision ID: PRELIM Stop 
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Start Date: 6/22/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 6/29/2011 Req'd Qty: 10.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>L.A</i>	<i>11/06/29</i>		<i>10</i>	<i>0</i>		
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>amk</i>	<i>11/06/30</i>		<i>10</i>	<i>0</i>		
151  Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo	0.00 0.00	<i>SB</i>	<i>11/07/07</i>		<i>10</i>			

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Item ID: D4353-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bearpaw Insert

Start Date: 6/22/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11

ME

11-07-07

Picklist Print

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Page 1

Work Order ID: 71095



Parent Item: D4353-3



Parent Item Name: Bearpaw Insert

Start Date: 6/22/2011

Required Date: 6/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

290.5000

2.105263



B11-6-28

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

290.5

117321

76.6

117738

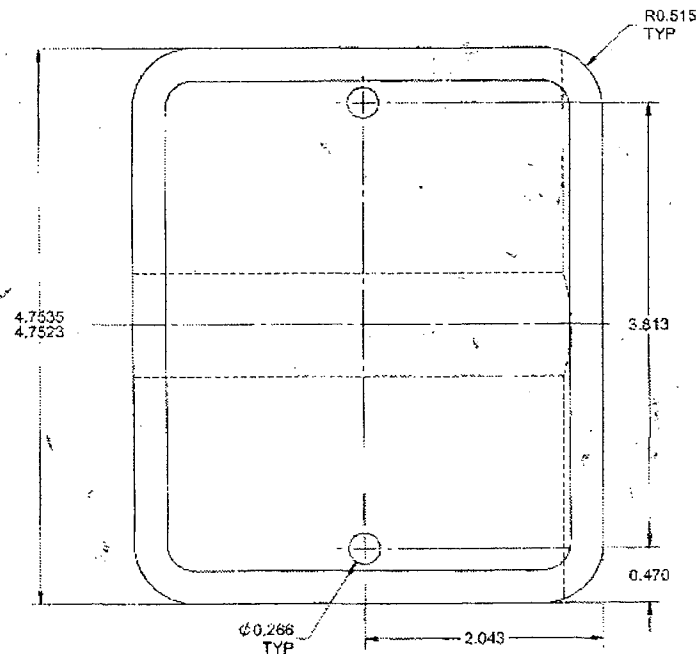
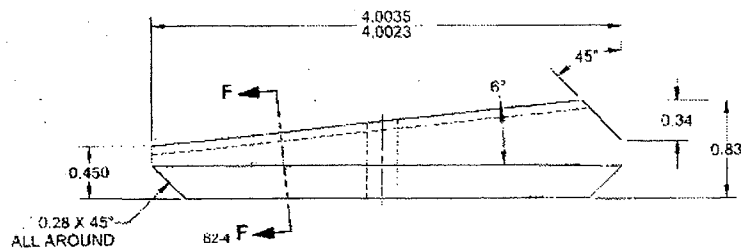
59

117819

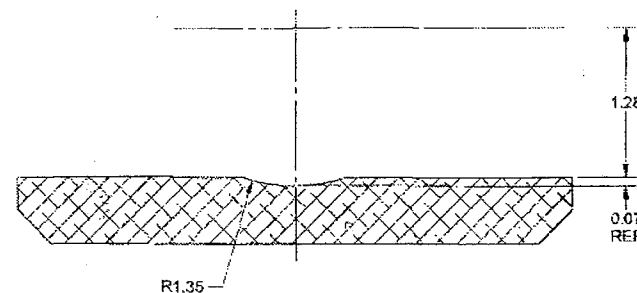
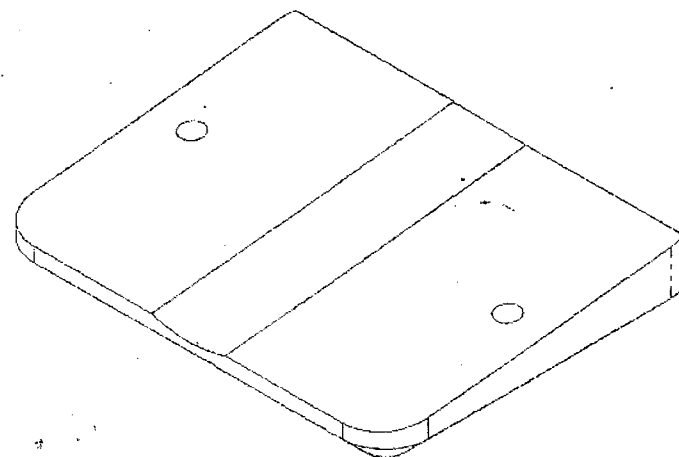
154.9

117738

(10)



D4353-3 429 BEARPAW INSERT



SECTION F-F U7-4

RELEASED
2011-05-24
JAN

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
UE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	